

EQUIP. TYPE R390A/URR - SHIP NO.

COL. 5407527-003

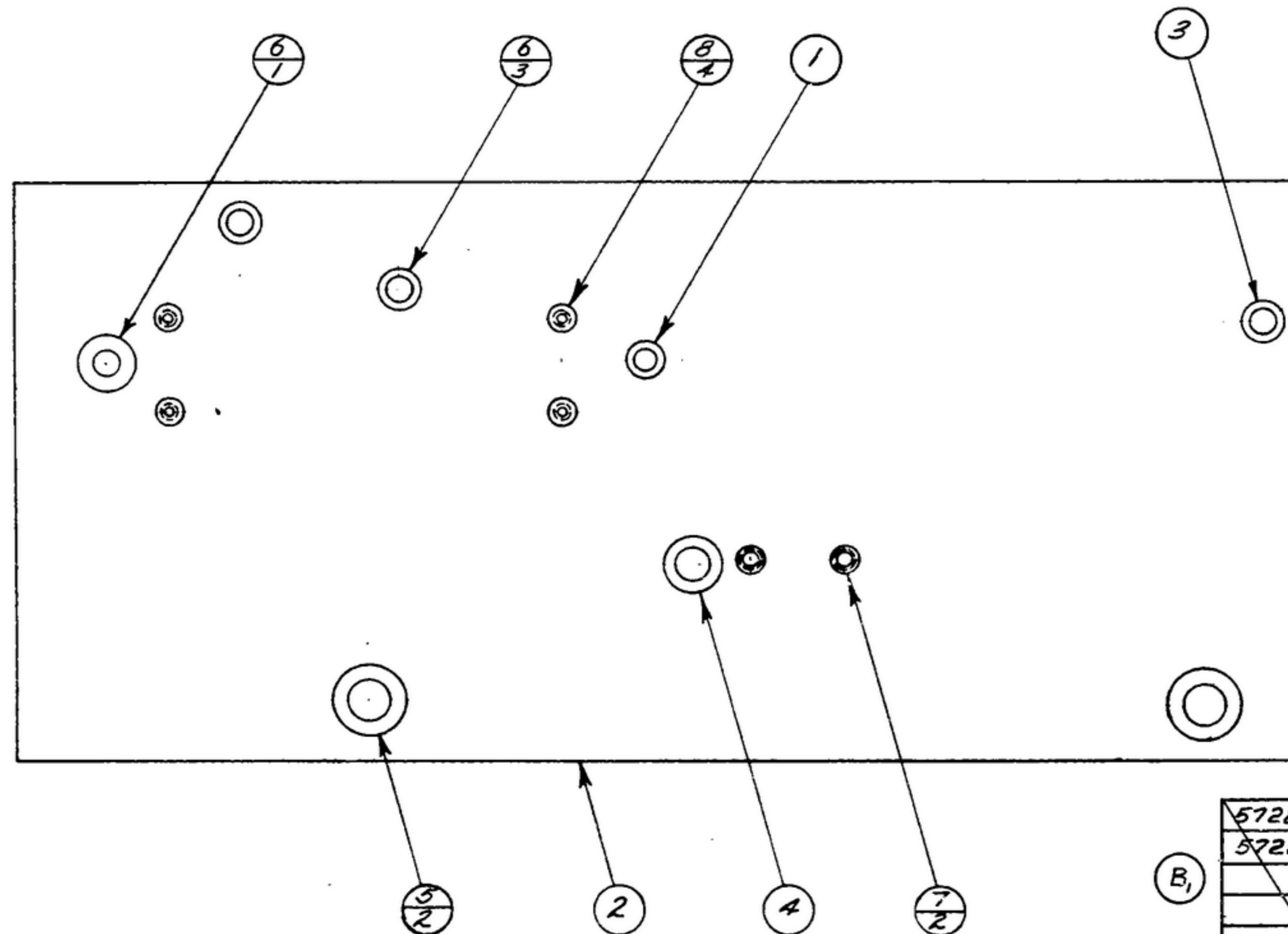
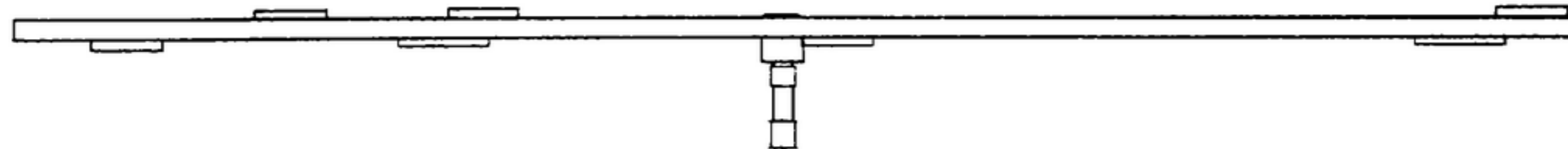
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*FOR INFORMATION ONLY. CONTRACTOR MAY AT HIS OPTION DEVIATE FROM THESE PROCESS DETAILS.

REVISIONS

SYM	DESCRIPTION	DATE	APPROVAL
A,	(1) ADDED S.W.E. PART NO.	16 MAR. 60	42428-PC-59 PME
B,	(1) ITEM 6. 3REQD WAS 4REQD.	22 JULY 60	42428-PC-59 PME



- NOTES:
- PRESS BEARINGS, ITEMS (4, 5 & 6), & NUTS ITEMS (7 & 8), INTO PLATE, ITEM (2) AS SHOWN.
 - BURNISH BEARINGS (5) TO $3.125 \pm .0005$ DIA, BEARING (4) TO $.2500 \pm .0005$ DIA, & BEARINGS (6) & (3) TO $.1875 \pm .0010$ DIA.
 - PRESS SHAFT, ITEM (1) INTO PLATE, ITEM (2), & ROLL.
 - PLATE TO BE FLAT WITHIN .020 T.I.R.
 - IN ALL SPLIT BALLOONS TOP FIGURE IS MATERIAL LIST ITEM INDICATOR & BOTTOM FIGURE IS QUANTITY.

572827-18	8	4	SM-C-283166-7	NUT-INSERT CAPTIVE			
572827-5	7	2	SM-C-283166-4	NUT-INSERT CAPTIVE			
			6	3	SM-B-283158	BEARING	
			5	2	SM-C-283156-3	BEARING	
			4	1	SM-C-283156-2	BEARING	
			3	1	SM-C-283156-1	BEARING	
			2	1	SM-C-248965	PLATE-AUX. GEAR	
			1	1	SM-B-12895	SHAFT	
A,	*S.W.E. PART NO.	ITEM	REQD	PART NO.	DESCRIPTION	MATL	MATL SPEC

LIST OF MATERIAL - COLLINS PART NO. 658-0315003

DRAWN ECS		CHECKED R	APPROVED	COLLINS RADIO CO. CEDAR RAPIDS, IOWA 14214-PH-51-93 SIGNAL CORPS	PLATE ASSY AUXILIARY GEAR	DEPARTMENT OF THE ARMY SIGNAL CORPS ENGINEERING LABORATORIES
UNLESS OTHERWISE SPECIFIED: DECIMAL DIMENSIONS INCLUDING HOLE SIZES MAY VARY $\pm .008$ FRACTIONAL DIMENSIONS INCLUDING HOLE SIZES MAY VARY $\pm 1/64$ MACHINED ANGLES MAY VARY $\pm 1^\circ$ SHEARED ANGLES MAY VARY $\pm 25'$ BROKEN ANGLES MAY VARY $\pm 1^\circ$ ECCENTRICITY BETWEEN ANY DIAMETERS ON THE SAME CENTERLINE SHALL NOT EXCEED .010 TOTAL INDICATOR READING. ALL DIMENSIONS ARE FINISH DIMENSIONS INCLUDING APPLIED FINISH AND ARE GIVEN IN INCHES.				REVIEWED PME		FORT MONMOUTH NEW JERSEY
568-0324004	1	SM-D-28975	SC-DL-248775	APPROVED HLY PME		SM-C-248966
COLLINS NO.	QTY	NEXT ASSY	USED ON	DATE 28 DEC 55	SCALE 1/1	
APPLICATION						